

Work Order ID 92499

92499

Page 1

October-31-12 10:16:30 AM

Item ID: D350-607-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Automatic Lid Opener Installation

Stop

NS2

Start Date: 10/31/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-11-01 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	JB	DAS 15 8-89	12/11/08					
D350-607-1	A								

100

100

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-607-145
CHG001.

110

110

Packaging

Packaging

Pick Kit

0.00

12/11/07 JB

Memo

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

DAS
15
8-89

12/11/08

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Grain	General			Ovalized	Pressure/Forced		
Centre Not Concentric to O/S	Bend	General			Hardware	General			Over/Under tolerance	Temperature/Cure	
Cracks	BOM/Route	General			Inspection Incomplete	General			Part Incorrect	Weld	
Crushed/Crimped.	Broken/Damaged	General			Instructions Incomplete/Unclear	General			Part Lost/Missing	Wrong Stock Pulled	
Cuffs	Burrs	General			Maintenance	General			Part Moved		
Heat Treat	Contamination	General			Mislabeled	General			Positioned Wrong		
Inspection Strip in Tube	Countersink	General			Misread	General			Power Loss/Surge		
Ripples in Bend	Cut Too Short	General			Offset	General				Other	
Torque Waves in Extrusion	Drill Holes	General			Out of Calibration	General					
Turning Sequence	Drawing	General			Out of Sequence	General					
Wave/Twist in Tube	Finish	General			Outside Dimensions	General					
	Folio	General				General					

Work Order ID 92499

92499

Page 2

October-31-12 10:16:30 AM

Item ID: D350-607-145

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Automatic Lid Opener Installation

Stop

NS2

Start Date: 10/31/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

Q

12/11/08

Memo

0.00

Identify and pack for shipping as per PPP D350-607-145

Location: 100

PPP rev: A

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/11/08

ML 12-11-08

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Picklist Print

October-31-12 10:16:29 AM

Page 1

Work Order ID: 92499

Parent Item: D350-607-145

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/31/12

Required Date: 11/16/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

IPP RevB: as per dwg revC DD

10.01.18 verified by:EC

IPP Rev:C as per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-1 Gas Spring Bracket		Manufactured	No			110	Each	6.0000		1		JB	
							<u>Location</u>		<u>Loc Qty</u>				
					ST076			6					
							53760		6				
D3953-3 Gas Spring Stud, Lid		Manufactured	No			110	Each	52.0000		1		JB	
							<u>Location</u>		<u>Loc Qty</u>				
					GA			2					
							87592		2				
					ST076			50					
							88494		26				
							89337		24				
D3953-5 Gas Spring Stud, Base		Manufactured	No			110	Each	27.0000		1		JB	
							<u>Location</u>		<u>Loc Qty</u>				
					ST076			27					
							85958		7				
							86593		20				
D3953-7 Spring Spacer		Manufactured	No			110	Each	56.0000		1		JB	12/11/07
							<u>Location</u>		<u>Loc Qty</u>				
					ST076			56					
							87444		20				
							88393		24				
							89248		12				

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

Picklist Print

October-31-12 10:16:29 AM

Page 2

Work Order ID: 92499

Parent Item: D350-607-145

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/31/12

Required Date: 11/16/12

Start Qty: 1.00

Required Qty: 1.00

D3953-9
Gas Spring/Washer

Manufactured No 110 Each 51.0000

2

JB

Location Loc Qty Loc Code

ST076 51 88462
89307 21
30

88462

D3953-11
Gas Spring Spacer

Manufactured No 110 Each 10.0000

1

JB

Location Loc Qty Loc Code

ST076 10 87089
87089 10

87089

D3953-13
Gas Spring Spacer

Manufactured No 110 Each 15.0000

1

JB

Location Loc Qty Loc Code

ST076 15 52761
52761 3
89247 12

52761

D3969-1
Spring (Basket Lid)

Manufactured No 110 Each 10.0000

1

JB

Location Loc Qty Loc Code

ST272 10 84424
73523 1
84424 9

84424

AN3G1A
BOLT

Purchased No 110 Each 40.0000

2

JB

119798

Location Loc Qty Loc Code

ST351 40 119798
122808 10
30

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General								
Bending	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric to O/S	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
Cracks	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>					
Crushed/Crimped.	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
Cuffs	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>						
Heat Treat	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
Inspection Strip in Tube	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
Ripples in Bend	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>							
Torque Waves in Extrusion	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Turning Sequence	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							
Wave/Twist in Tube	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>							

Picklist Print

October-31-12 10:16:29 AM

Page 3

Work Order ID: 92499

Parent Item: D350-607-145

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/31/12

Required Date: 11/16/12

Start Qty: 1.00

Required Qty: 1.00

AN3G16A
Bolt

Purchased No

110 Each 41.0000

2 ✓ JB

SM3

Location	Loc Qty	Loc Code
ST512	41	
115835	1	
121349	25	
121652	3	
122814	12	

AN310-4
NUT

Purchased No

110 Each 71.0000

2 ✓ JB

SM3

Location	Loc Qty	Loc Code
ST342	69	
122800	69	
ST344	2	
121349	2	

MS21043-3
Nut

Purchased No

110 Each 318.0000

4 ✓ 123525 ✓ JB

SM3

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	79	
118077	2	
118614	7	
118686	30	
119758	20	
121255	20	
ST315	167	
122993	167	

MS24665-2-12
COTTER PIN

Purchased No

110 Each 100.0000

2 ✓ JB 12/14/07

SM3

Location	Loc Qty	Loc Code
ST309	100	
118078	100	

118078

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

Picklist Print

October-31-12 10:16:29 AM

Page 4

Work Order ID: 92499

Parent Item: D350-607-145

Parent Item Name: Automatic Lid Opener Installation

Start Date: 10/31/12

Required Date: 11/16/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Washer

5mB

Purchased

No

110

Each

2,807.0000

4

4

✓

JB

SP

Location

Loc Qty

Loc Code

ST292

2807

123248

839

123355

1968

Purchased

No

110

Each

4,652.0000

2

2

✓

123355

NAS1149C0432R

Washer

SH

Location

Loc Qty

Loc Code

296

3000

122441

3000

ST297

1036

117291

40

119124

996

ST298

616

121255

616

121255

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge					
						<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled					
						<input type="checkbox"/> Other					

6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
		1	D3953-15	GAS SPRING BRACKET
		1	D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)